

New claims:

12.⁹ A method of producing flat-blade windshield wipers for

motor vehicles with curved flat blades, the method comprising the steps of:

feeding a spring band formed of a plurality of flat blades arranged one next to another in a direction of elongation of said spring band through feed rolls and guide rolls;

C2 bending said spring band in one transversal direction between three support sites spaced from each other in a direction of feeding of said spring band and resting successively in an alternating manner on one of two sides of said spring band;

re-bending said spring band in another transversal direction opposite to said one transversal direction in a fourth support site arranged subsequently to said three support sites by a degree of re-bending lower than a bending degree in said bending step;

separating each individual flat blade of a re-bent spring band from a remaining spring band;

mounting a connection device for a wiper arm to said flat blade;

and

combining each individual flat blade with a rubber-elastic wiping bar;

wherein in said bending step, a central support site of said three support sites and, in said re-bending step, said fourth support site are each displaceable transversely to said spring band in a direction of a width of said spring band, and

wherein transverse displacements of said central support site and said fourth support site are controlled according to preset programs which take into account changes in the material thickness in said flat blades.

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13. A method of producing flat-blade windshield wipers for motor vehicles with curved flat blades, the method comprising the steps of:

feeding a spring band formed of a plurality of flat blades arranged one next to another in a direction of elongation of said spring band through feed rolls and guide rolls;

bending said spring band in one transversal direction between three support sites spaced from each other in a direction of feeding of said spring band and resting successively in an alternating manner on one of two sides of said spring band;

re-bending said spring band in another transversal direction opposite to said one transversal direction in a fourth support site arranged subsequently to said three support sites by a degree of re-bending lower than a bending degree in said bending step;

adjusting a degree of bending to realize different bending radii within one bending process;

separating each individual flat blade of a re-bent spring band from a remaining spring band;

mounting a connection device for a wiper arm to said flat blade; and

combining each individual flat blade with a rubber-elastic wiping bar;

wherein at least one of said three support sites for bending the spring band in said bending step is designed as a cutting edge, and

wherein said separating step includes passing a cutter along said cutting edge.

14. A method of producing flat-blade windshield wipers for motor vehicles with curved flat blades, the method comprising the steps of:

feeding a spring band formed of a plurality of flat blades arranged one next to another in a direction of elongation of said spring band through feed rolls and guide rolls;

bending said spring band in one transversal direction between three support sites spaced from each other in a direction of feeding of said

spring band and resting successively in an alternating manner on one of two sides of said spring band;

re-bending said spring band in another transversal direction opposite to said one transversal direction in a fourth support site arranged subsequently to said three support sites by a degree of re-bending lower than a bending degree in said bending step;

adjusting a degree of bending and/or re-bending to realize different bending radii within one bending process;

separating each individual flat blade of a re-bent spring band from a remaining spring band;

mounting a connection device for a wiper arm to said flat blade;

combining each individual flat blade with a rubber-elastic wiping bar; and

optically measuring and comparing said flat blades with specified nominal values and using mean deviations from said nominal values for correcting programs in said bending step and said re-bending step.